

39. A filled waffle as recited in claim 33, wherein said emulsifier comprises at least one of a glycerol ester, a diacetyl tartaric acid, an ester of a monoglyceride, a monoglyceride, a di-glyceride, a polyglycerol ester, a polysorbate, a propylene glycol ester, a rice extract ester, a sodium stearoyl-2-lactylate, a sorbitan ester, a lecithin, a sugar ester, an acetylated monoglyceride, or mixtures thereof.

40. A filled waffle as recited in claim 33, wherein said acidulant comprises at least one of citric acid, malic acid, tartaric acid, lactic acid, acetic acid, phosphoric acid, adipic acid, glucono delta lactone acid, fumaric acid, succinic acid, tarenic acid, or mixtures thereof.

41. A filled waffle as recited in claim 33, wherein said gum comprises at least one of pectin, guar, locust bean, tara, gellan, alginate, tragacanth, karaya, Ghatti, agar, gelatin, arabic, acacia, carrageenan, xanthan, cellulose, carboxymethylcellulose, hydroxypropylmethocellulose, or mixtures thereof.

42. A filled waffle as recited in claim 33, wherein said salt comprises at least one of sodium chloride, potassium chloride, calcium chloride, and mixtures thereof.

43. A filled waffle as recited in claim 33, wherein said coloring agent comprises at least one of natural coloring agent, an artificial coloring agent, or mixtures thereof.

44. A filled waffle as recited in claim 33, wherein said antimycotic preservative comprises at least one of sodium benzoate, potassium sorbate, sodium propionate, calcium propionate or mixtures thereof.

45. A filled waffle as recited in claim 33, wherein said humectant comprises at least one of glycerin, sorbitol, fructose, propylene glycol, or mixtures thereof.

46. A filled waffle as recited in claim 33, wherein said fortificant comprises at least one of ascorbic acid, beta carotene, biotin, calcium pantothenate, choline, folic acid, niacin, Vitamin A, Vitamin B₁, Vitamin B₂, Vitamin B₆, Vitamin B₁₂, Vitamin D₂, niacinamide, Vitamin D₃, Vitamin E, Vitamin K, boron, calcium, chromium, copper, iodine, iron, magnesium, molybdenum, nickel, potassium, selenium, vanadium, zinc, calcium citrate, calcium gluconate, calcium lactate, calcium caseinate, calcium chloride, calcium citrate malate, calcium glycerophosphate, calcium hydroxide, calcium malate, calcium stearate, calcium sulfate, or mixtures thereof.

47. A filled waffle as recited in claim 33, wherein said protein comprises at least one of egg albumen, whey protein, soy protein, vital wheat gluten, peanut protein, pea protein, or mixtures thereof.

48. A filled waffle as recited in claim 26, wherein the ratio of said outer casing material to said filling material ranges from 2:1 to 8:1.

49. A filled waffle as recited in claim 26, wherein said outer casing material further comprises from 40 to 45 percent by weight water, from 35 to 40 percent by weight hard wheat flour, from 6 to 15 percent by weight shortening, from 3 to 7 percent by weight liquid whole egg, from 0.5 to 3 percent by weight whey, from 1 to 5 percent by weight sugar, from 0.5 to 1 percent by weight baking soda, from 0.4 to 0.7 percent by weight sodium aluminum phosphate, from 0.25 to 1 percent by weight salt, and from 0.1 to 0.5 percent by weight monocalcium phosphate.

50. A filled waffle as recited in claim 26, wherein said filling material further comprises 20 to 25% by weight water, 40 to 45% by weight sweeteners, 2 to 10% by weight dry fruit flakes, 2 to 5% by weight instant modified starch, 0.2 to 0.5% by weight citric acid, 0.2 to 0.5% by weight fruit flavoring, 0.1 to 0.5% by weight xanthan gum, 0.2 to 0.5% by weight emulsifier, 0.1 to 0.4% by weight malic acid, 0.1 to 0.4% by weight coloring, 0.1 to 0.5% by weight flavoring other than fruit flavoring, and 0.1 to 0.5% by weight salt.

51. A baked freezer stable filled waffle comprising:

an outer casing material formed from a batter comprising a homogenous mixture of from 30 to 65 percent by weight water, from 25 to 70 percent by weight of a flour, from 0.05 to 2.5 percent by weight of a bicarbonate and from 0.04 to 2 percent by weight of a leavening acid;

said outer casing material surrounding a filling material formed from a mixture of a sweet flavored filling comprising from 1 to 40% by weight water, from 35 to 80% by weight sweetener, from 0.5 to 5% by weight starch, from 0.1 to 3% by weight gum, and from 0.01 to 5% by weight flavoring; and

wherein said outer casing material has a water activity level of from 0.9 to 0.99 and said filling material has a water activity level of less than or equal to 0.95 with said water activity level of said filling material being less than said water activity level of said outer casing material.

52. A filled waffle as recited in claim 51, wherein said filling material has a water activity level of from 0.7 to 0.95.

53. A filled waffle as recited in claim 51, wherein said filling material has a water activity level of from 0.80 to 0.90.

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